

We claim:

1. A pair of stretchable athletic pants comprising:
5 a body portion comprising:
a panel of a stretchable material comprising a first edge,
a second edge overlapping said first edge of the panel forming an
overlapping region, said panel being bonded in at least a portion of said
overlapping region via an overlapping bonded seam,
10 wherein said body portion further defines a crotch and buttocks region, a
waist opening and two leg openings such that a user can insert a leg
through each of said leg openings and pull said body portion upward into
a wearing position.
- 15 2. The stretchable athletic pants of claim 1, wherein said overlapping bonded
seam comprises a substantially flat seam.
3. The stretchable athletic pants of claim 1, wherein said overlapping bonded
seam comprises a curved seam.
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4. The stretchable athletic pants of claim 3, wherein said overlapping bonded
seam comprises a curved seam comprising a minimum radius of curvature of at
least about 4 centimeters.
- 25 5. The stretchable athletic pants of claim 1, wherein said overlapping bonded
seam comprises a straight seam.

6. The stretchable athletic pants of claim 1, wherein said overlapping bonded seam comprises a bonding agent disposed in at least a portion of said overlapping region.
- 5 7. The stretchable athletic pants of claim 1, wherein said overlapping bonded seam comprises said panel being directly bonded in at least a portion of said overlapping region.
8. The stretchable athletic pants of claim 1, wherein said panel of stretchable
10 material comprises an elastic material.
9. The stretchable athletic pants of claim 1, wherein said panel of stretchable material comprises a moisture wicking material.
- 15 10. The stretchable athletic pants of claim 1, wherein said panel of stretchable material comprises a multi-layered denier gradient structure.
11. The stretchable athletic pants of claim 1, wherein the pants comprise pants selected from one or more of the group comprising: a pair of athletic shorts, a
20 pair of cycling shorts, a pair of athletic pants, a pair of cycling pants, a bib, a cycling bib, a pair of tights, a pair of briefs.
12. The stretchable athletic pants of claim 1, further comprising a chamois disposed adjacent at least a portion of said panel of stretchable material.
- 25 13. The stretchable athletic pants of claim 12, wherein said chamois is disposed in said crotch and buttocks region of said body portion.

14. The stretchable athletic pants of claim 1, wherein said second edge comprises a second edge of said panel.
15. The stretchable athletic pants of claim 1, wherein said second edge
5 comprises an edge of a second panel.
16. The stretchable athletic pants of claim 1, wherein the pants are designed to be worn as a base layer.
- 10 17. The stretchable athletic pants of claim 1, wherein said panel comprises a nylon and spandex blend.
18. The stretchable athletic pants of claim 17, wherein said panel further comprises a nylon, polyester and spandex blend.
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19. The stretchable athletic pants of claim 1, wherein said seam comprises a structural seam.
20. A pair of cycling pants comprising:
20 a body portion comprising a first panel of an elastic material and a second panel of an elastic material attached along a seam, said body portion further comprising a crotch and buttocks region, a waist opening and two leg openings such that a user can insert a leg through each of said leg openings and pull said body portion upward into a wearing position,
25 wherein said seam comprises an overlapping bonded seam.
21. The cycling pants of claim 20, wherein said overlapping bonded seam comprises a substantially flat seam.

22. The cycling pants of claim 20, wherein said overlapping bonded seam comprises a curved seam.
- 5 23. The cycling pants of claim 22, wherein said overlapping bonded seam comprises a curved seam comprising a minimum radius of curvature of at least about 4 centimeters.
24. The cycling pants of claim 20, wherein said overlapping bonded seam
10 comprises a straight seam.
25. The cycling pants of claim 20, wherein said overlapping bonded seam comprises a bonding agent disposed in at least a portion of an overlapping region of said first panel and said second panel.
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26. The cycling pants of claim 20, wherein said overlapping bonded seam comprises said first panel and said second panel directly bonded in at least a portion of an overlapping region of said first panel and said second panel.
- 20 27. The cycling pants of claim 20 further comprising a chamois disposed in said crotch and buttocks region of said body portion.
28. A method of making stretchable athletic pants comprising:
providing a panel of a stretchable material having a first edge;
25 providing a second edge;
overlapping said first edge and said second edge to form an overlapping region;

bonding said panel in at least a portion of said overlapping region to provide an overlapping bonded seam; and

forming a body portion of a pair of stretchable athletic pants comprising said panel, said body portion comprising a crotch and buttocks region, a waist
5 opening and two leg openings such that a user can insert a leg through each of said leg openings and pull said body portion upward into a wearing position.

29. The method of claim 28, wherein said overlapping bonded seam comprises a substantially flat seam.
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30. The method of claim 28, wherein said bonding operation comprises directly bonding said panel in said overlapping region.

31. The method of claim 28, wherein said bonding operation comprises
15 bonding said panel in said overlapping region using a bonding agent.

32. The method of claim 31, wherein said bonding agent comprises a thermoplastic polyurethane adhesive.

20 33. The method of claim 28, wherein said overlapping bonded seam comprises a straight seam.

34. The method of claim 28, wherein said overlapping bonded seam comprises a curved seam.
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35. The method of claim 34, wherein said curved seam comprises a minimum radius of curvature of at least about 4 centimeters.

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36. The method of claim 28, further comprising disposing a chamois in said crotch and buttocks region of said body portion.

37. The method of claim 28, wherein said first panel of stretchable material
5 comprises an elastic material.

38. The method of claim 28, wherein said second edge of the pants comprises a second edge of said panel.

10 39. The method of claim 28, wherein said second edge of the pants comprises an edge of a second panel.